

Date: Wednesday, 4/12/2006 3:36:44 PM
 User: Linda Lacelle

Process Sheet

Split
06/05/19

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LABEL PLATE
Job Number : 26631-2	
Estimate Number : 10599	
P.O. Number : <i>NIA</i>	Part Number : D2506
This Issue : 4/12/2006 S.O. No. : <i>NIA</i>	Drawing Number : D2506 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : PURCHASED PARTS	Drawing Revision : D1
Previous Run : 24875	Material : <i>NIA</i>
Written By : <i>SEE COMMENT BELOW</i>	Due Date : 4/19/2006
Checked & Approved By : <i>SEE ABOVE USER & DATE</i>	Qty: <i>50</i> Um: Each
Comment : Est. B 01.06.08 Now laser cut EC	<i>ml F. 06-04-25.</i>

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *1022*

Laser Cut per Dwg D2506

Material: AISI 304/316 SS 20 gauge (0.040" thick)

Material release note required

✓ *06-04-18*

2.0 D2506F Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 25.0000 Each(s)
 Placard

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

AL 06/04/24 50

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-04-24 50

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr

06 : 06/05/19 50

Date: Wednesday, 4/12/2006 3:36:44 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 26631

Part Number: D2506

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

DB

04/05/19

40

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.05.23

40

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS 15

06/05/23

40

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/25

06/05/25

40

Job Completion

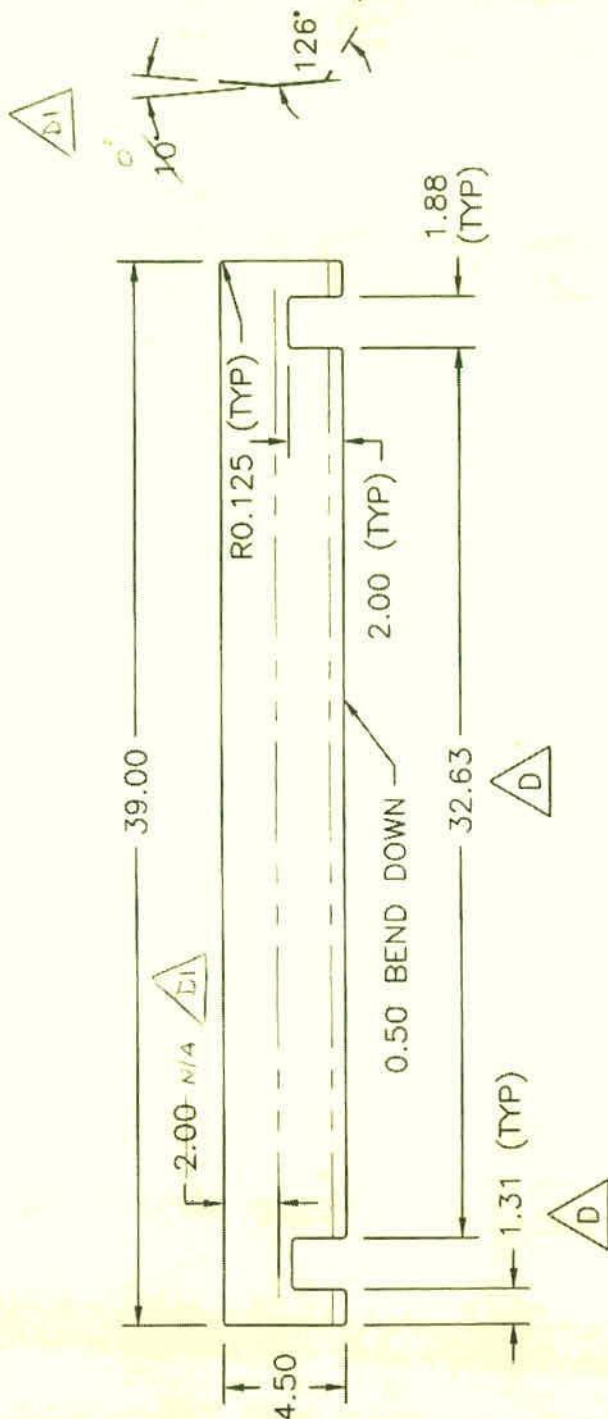


06.05.25



DESIGN	BW	DRAWN BY	KE	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	KE	DRAWING NO.	REV. D
				D2506	SHEET 1 OF 1
DATE	99.10.04	TITLE	LABEL PLATE	SCALE	1:7
B	96.06.18	REDESIGN OF LABEL PLATE			
C	96.09.04	REDESIGN OF LABEL PLATE			
D	99.10.04	32.63 WAS 32.25, 1.31 WAS 1.50			
D1	99.06.23	0" WAS 10"			

RELEASED
99.10.12 KE



D2506 FLAT PATTERN

NOTE: USE R0.08 BEND RADIUS

MATERIAL: AISI 304/316 SS, 0.040 THICK (20 GAUGE)

99.10.04
99.10.04



METALLURGICAL TEST REPORT

NORTH AMERICAN STAINLESS CANADA, INC.
740 IMPERIAL ROAD NORTH
GUELPH, ON N1K1Z3

NORTH AMERICAN STAINLESS CANADA, INC.

Certificate: 5765 2 Mail To:
WILKINSON STEEL AND METALS
888 SOUTHEAST DRIVE
VANCOUVER, BC V5X2V3

Ship To:
WILKINSON STEEL AND METALS
888 SOUTHEAST DRIVE
VANCOUVER, BC V5X2V3

Date: 2/22/2006 Page: 1

Steel: 304

Finish: 2B

Your Order: P51219PC002

NAS Order: IN 0005282 02

Corrosion: ASTM A262/02aE; 180Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a, 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q0S765D-A X MG PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q0S763P Cond A

Product Id	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces	Commodity Code
B44277	B44277	.0345	48.0000	3,325 SHEETS	096.00	2	73	

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States)

Heat	CM	C	CR	CU	MN	MO	N	NI	P	S	SI
88W5	US	.056	18.108	.365	1.639	.321	.050	8.210	.027	.001	.304

MECHANICAL PROPERTIES

Product Id#	Coil #	ld oi cr	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard
B44277	0288W5	P T	98.48	49.21	55.28	78.50	81.00

QC ENGINEER

ERIC HESS

3/10/2006

